

ATTORNEY'S DOCKET NO: 24552

BOX PCT

U.S. DEPARTMENT OF COMMERCE, PATENT AND TRADEMARK OFFICE		DATE: 30 March 2001 (30 .03.2001)
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371		U.S. APPL. NO. (If known) Not Yet Assigned 09/806442
INTERNATIONAL APPLICATION NO.: PCT/EP99/07257	INTERNATIONAL FILING DATE: 30 September 1999 (30.09.99)	PRIORITY DATE CLAIMED: 02 October 1998
TITLE OF INVENTION: METHOD FOR THE MANUFACTURE OF PROSTHETIC MOULDED PARTS FOR THE DENTAL SECTOR AND PROSTHETIC MOULDED PART		
APPLICANT(S) FOR DO/EO/US: RUEBEL, Susanne		
Applicant hereby submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:		
<p>1. <u>X</u> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371.</p> <p>2. <u> </u> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371.</p> <p>3. <u>X</u> This express request to begin national examination procedures (35 USC 371(f)) The submission must include items(5), (6), (9) and (21) indicated below.</p> <p>4. <u>X</u> A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.</p> <p>5. <u>X</u> A copy of the International Application as filed (35 U.S.C. 371(c)(2)):</p> <p style="margin-left: 40px;">a. <u>X</u> is transmitted herewith (required only if not transmitted by the International Bureau).</p> <p style="margin-left: 40px;">b. <u> </u> has been communicated by the International Bureau.</p> <p style="margin-left: 40px;">c. <u> </u> is not required, as the application was filed in the United States Receiving Office (RO/US)</p> <p>6. <u>X</u> A English translation of the International Application as filed (35 U.S.C. 371(c)(2)).</p> <p>7. <u>X</u> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))</p> <p style="margin-left: 40px;">a. <u> </u> are attached hereto (required only if not transmitted by the International Bureau).</p> <p style="margin-left: 40px;">b. <u> </u> have been communicated by the International Bureau.</p> <p style="margin-left: 40px;">c. <u> </u> have not been made; however, the time limit for making such amendments has NOT expired.</p> <p style="margin-left: 40px;">d. <u>X</u> have not been made and will not be made.</p> <p>8. <u> </u> An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).</p> <p>9. <u> </u> An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).</p> <p>10. <u>X</u> A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).</p>		
ITEMS 11 to 20 BELOW CONCERN OTHER DOCUMENT(S) OR INFORMATION INCLUDED:		
<p>11. <u> </u> An Information Disclosure Statement under 37 CFR 1.97 and 1.98.</p> <p>12. <u> </u> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.</p> <p>13. <u>X</u> A FIRST preliminary amendment.</p> <p>14. <u> </u> A SECOND or SUBSEQUENT preliminary amendment</p> <p>15. <u> </u> A substitute specification.</p> <p>16. <u> </u> A change of power of attorney and/or address letter.</p> <p>17. <u> </u> A computer-readable form of the sequence listing in accordance with PCT Rule 13ter2 and 35 USC 1821 - 1825</p> <p>18. <u> </u> A second copy of the published international application under 35 USC 154(d)(4)</p> <p>19. <u> </u> A second copy of the English language translation of the international application under 35 USC 154(d)(4)</p> <p>20. <u>X</u> Other items or information:</p>		
<p>TRANSMITTAL FORM; FEE CALCULATION; INTERNATIONAL PUBLICATION WO 00/19936; INTERNATIONAL PUBLICATION DATE 13 APRIL 2000 WITH VERIFIED ENGLISH TRANSLATION CONSISTING OF 16 PAGES INCLUDING; 11 PAGES TEXTUAL SPECIFICATION, 3 PAGES OF 26 CLAIMS; 1 PAGE CONTAINING THE ABSTRACT; 1 SHEET DRAWINGS; PCT/ISA/210 INTERNATIONAL SEARCH REPORT; PCT/IPEA/416 NOTIFICATION OF TRANSMITTAL OF INTERNATIONAL PRELIMINARY EXAMINATION REPORT; PCT/IPEA/409 INTERNATIONAL PRELIMINARY EXAMINATION REPORT WITH ENGLISH TRANSLATION OF AMENDED SHEETS; PRELIMINARY AMENDMENT TO BE EXAMINED WITH CLEAN COPY OF AMENDMENTS; UNEXECUTED INVENTOR'S DECLARATION; PCT/RO/101 REQUEST; PCT/IB/304 NOTIFICATION CONCERNING SUBMISSION OR TRANSMITTAL OF PRIORITY DOCUMENT; PCT/IB/332 INFORMATION CONCERNING ELECTED OFFICES NOTIFIED OF THEIR ELECTION; PCT/IPEA/R02 NOTIFICATION OF RECEIPT OF DEMAND</p>		

ATTORNEY'S DOCKET NO: 24552

U.S. APPLICATION NO. <small>(if known, not yet assigned)</small> 09/806442		INTERNATIONAL APPLICATION NO. PCT/EP99/07257		DATE: 30 March 2001 (30 .03.2001)			
17. <input checked="" type="checkbox"/> The following fees are submitted: Basic National Fee (37 CFR 1.492(a)(1)-(5): Search Report has been prepared by the EPO or JPO:.....\$860.00 International preliminary examination fee paid to USPTO (37 CFR 1.482).....\$690.00 No international preliminary examination fee paid to USPTO (37 CFR 1.482) but international search fee paid to USPTO (37 CFR 1.445(a)(2)).....\$710.00 Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO.....\$1000.00 International preliminary examination fee (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(2)-(4).....\$ 100.00 ENTER APPROPRIATE BASIC FEE AMOUNT =				CALCULATIONS \$ 860.00 \$ 860.00		PTO USE ONLY	
Surcharge of \$130.00 for furnishing the oath or declaration later than <u> 20 </u> <u> 30 </u> months from the earliest claimed priority date (37 CFR 1.492(e)).				\$			
CLAIMS	NO. FILED	NO. EXTRA	RATE				
TOTAL	<u>25</u> -20=	5	X \$ 18.00	\$	90.00		
INDEPENDENT	<u>1</u> - 3=	2	X \$ 80.00	\$	0.00		
Multiple dependent claims(s) (if applicable)			+ \$260.00	\$	0.00		
TOTAL OF ABOVE CALCULATIONS =				\$	950.00		
Reduction by 1/2 for asserting small entity, if applicable. (Note 37 CFR 1.9, 1.27, 1.28).				\$	0.00		
SUBTOTAL =				\$	950.00		
Processing fee of \$130.00 for furnishing the English translation later than <u> 20 </u> <u> 30 </u> months from the earliest claimed priority date (37 CFR 1.492(f)).				\$	0.00		
TOTAL NATIONAL FEE =				\$	950.00		
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40.00 per property +				\$	0.00		
TOTAL FEES ENCLOSED =				\$	950.00		
				Amount to be: refunded	\$		
				charged	\$		

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U.S. APPLICATION NO. (if known) not yet assigned 097806442	INTERNATIONAL APPLICATION NO. PCT/EP99/07257	DATE: 30 March 2001 (30 03.2001)
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a. ☒ Two checks in the amount of \$950.00 to cover the above fees are enclosed.

b. ☐ Please charge my Deposit Account No. 14-0112 in the amount of \$_____ to cover the above fees. (A duplicate copy of this sheet is enclosed.)

c. ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. 14-0112.

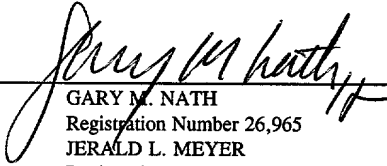
d. Fees are to be charged to a credit card ____ WARNING: Information on this form may become public ____ Credit Card Information should not be included on this form. ____ Provide credit card information and authorization on PTO-2038 ____

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed to request that the application be restored to pending status.

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Rev. 02/98

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Application of:

RUEBEL, Susanne

International Application No. PCT/EP99/07257

Serial No. NOT YET ASSIGNED

International Filing Date: 30 September 1999 (30.09.99)

Filed: March 30, 2001

For: **METHOD FOR THE MANUFACTURE OF PROSTHETIC MOULDED PARTS FOR THE
DENTAL SECTOR AND PROSTHETIC MOULDED PART**

PRELIMINARY AMENDMENT

Commissioner for Patents

Washington, D.C. 20231

Sir:

Prior to examining on the merits and calculating the filing fee for the national phase application filed herewith, please enter the following amendments:

IN THE CLAIMS:

Please cancel Article 34 amended claims 1-25 and submit the following new set of claims 26-50, as attachment A, without prejudice.

REMARKS

The above amendments have been made to remove multiple dependencies from the claims and to conform them to U.S. practice. No new matter has been added. Pursuant to the new rules implementing the AIPA, a clean copy of the new claims is attached.

Respectfully submitted,

NATH & ASSOCIATES PLLC

By: 

Gary M. Nath

Registration No. 26,965

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Date: March 30, 2001

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GMN/dd:AMENDpreml.AIPA

Attachment A (Clean copy of claims)

CLAIMS

26. Method for the manufacture of prosthetic moulded parts for the dental sector with the aid of galvanic metal deposition, in which galvanic deposition at least partly takes place by pulse-plating, characterized in that gold or a gold alloy is deposited and that the percentage pulse duration, based on the total deposition time, is at least 50%.
27. Method according to claim 26, characterized in that galvanic deposition is ended in a time of less than 5 hours.
28. Method according to claim 27, characterized in that galvanic deposition is ended within 1 to 2 hours.
29. Method according to claim 26, characterized in that the percentage pulse duration is at least 70%.
30. Method according to claim 26, characterized in that square-wave or ramp-shaped current pulses are used.
31. Method according to claim 26, characterized in that the pulse current density is between 0.2 and 50 A/dm².
32. Method according to claim 26, characterized in that the duration of the current pulses or current intervals is in the millisecond range.
33. Method according to claim 32, characterized in that the duration of the current pulses is at least 1 ms.
34. Method according to claim 32, characterized in that the duration of the current intervals is at least 1 ms.
35. Method according to claim 26, characterized in that the prosthetic moulded part is deposited with a thickness of at least 100 µm, preferably between 150 and 300 µm.

36. Method according to claim 26, characterized in that galvanic deposition takes place from an aqueous bath.

37. Method according to claim 26, characterized in that galvanic deposition takes place from a gold sulphate bath.

38. Method according to claim 26, characterized in that galvanic deposition takes place from a bath, which contains the metal to be deposited in a higher concentration than conventional baths.

39. Method according to claim 38, characterized in that a gold sulphite bath has a gold concentration of more than 30 g/l.

40. Prosthetic moulded part for the dental sector obtainable according to the method of claim 26.

41. Prosthetic moulded part for the dental sector manufactured according to the method according to claim 26.

42. Prosthetic moulded part according to claim 40, characterized in that it is veneered with ceramic or plastic.

43. Electrolytic cell for the manufacturer of prosthetic moulded parts for the dental sector with the aid of galvanic metal deposition by pulse current or pulse-plating, for performing the method according to claim 26, comprising an outer anode constructed in such a way that it at least partly surrounds a cathode to be coated with metal and which can be place in the electrolytic cell, along a circumferential line enclosing the cathode.

44. Electrolytic cell according to claim 43, characterized in that the outer anode has several anode parts along the circumferential line.

45. Electrolytic cell according to claim 43, characterized in that the outer anode is cylinder envelope-shaped.

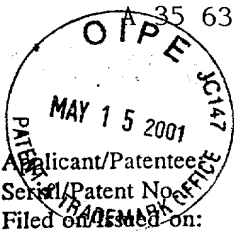
46. Electrolytic cell according to one of the claim 43, comprising a further inner anode, which is located within the circumferential line defined by the outer anode.

47. Electrolytic cell according to claim 43, characterized in that the inner anode is an anode rod.

48. Electrolytic cell according to claim 43, characterized in that between the outer and/or inner anode and the at least one cathode are provided shielding elements.

49. Electrolytic cell according to claim 48, characterized in that the shielding elements are made from plastic.

46. Electrolytic cell according to one of the claim 43, comprising a further inner anode, which is located within the circumferential line defined by the outer anode.



RUEBEL, Susanne

Applicant/Patentee

Serial/Patent No.

Filed on/Issued on:

For:

09/806442

Atty. Dkt No. 24552

March 30, 2001

VERIFIED STATEMENT (DECLARATION) CLAIMING SMALL ENTITY STATUS
(37 CFR § 1.9(d) AND § 1.27(b)) - SMALL BUSINESS CONCERN

I hereby declare that I am:

☐ The owner of the small business concern identified below:

☐ An official of the small business concern empowered to act on behalf of the concern identified below:

NAME OF CONCERN Wieland Edelmetalle GmbH & Co.

ADDRESS OF CONCERN Schwenninger Strasse 13, D - 75179 Pforzheim, Germany

I hereby declare that the above-identified small business concern qualifies as a small business concern as defined in 13 CFR § 121.8-18, and reproduced in 37 CFR § 1.9(d), for purposes of paying reduced fees under 35 USC § 41(a) and (b), in that the number of employees of the concern, including those of its affiliates, does not exceed 500 persons. For purposes of this statement: (1) the number of employees of the business concern is the average over the previous fiscal year of the concern of the persons employed on a full-time, part-time or temporary basis during each of the pay periods of the fiscal year, and (2) concerns are affiliates of each other when either, directly or indirectly, one concern controls or has the power to control the other, or a third party or parties controls or has the power to control both.

I hereby declare that the rights under contract or law have been conveyed to and remain with the small business concern identified above with regard to the invention entitled see *** by inventor(s) _____ described in:

☒ The specification filed herewith

☐ U.S. Application Serial No. _____, filed _____

☐ U.S. Patent No. _____, issued _____

If the rights held by the above-identified small business concern are not exclusive, each individual, concern or organization having rights to the invention is listed below* and no rights to the invention are held by any person, other than the inventor, who could not qualify as a small business concern under 37 CFR § 1.9(d) or by any concern which would not qualify as a small business concern under 37 CFR § 1.9(d) or a non-profit organization under 37 CFR § 1.9(e).

FULL NAME _____

ADDRESS _____

☐ Individual ☐ Small Business ☐ Non-Profit

*NOTE: Separate Verified Statements are required from each named person, concern or organization having rights to the invention averring to their status as small entities (37 CFR § 1.27).

I acknowledge the duty to file, in this application or patent, notification of any change in status resulting in loss of entitlement to small entity status prior to paying, or at the time of paying, the earliest of the Issue Fee or any maintenance fee due after the date on which status as a small entity is no longer appropriate (37 CFR § 1.28(b)).

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further, that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under 18 USC § 1001, and that such willful false statements may jeopardize the validity of the application, any patent issuing thereon, or any patent to which this Verified Statement is directed.

NAME OF PERSON SIGNING Dr. Manfred Stümke

TITLE OF PERSON SIGNING Technical Director

ADDRESS OF PERSON SIGNING Wieland Edelmetalle, Schwenninger Str. 13, D-75179 Pforzheim

Signature [Signature] Date 03/22/2001

DESCRIPTIONMETHOD FOR THE MANUFACTURE OF PROSTHETIC MOULDED PARTS
FOR THE DENTAL SECTOR AND PROSTHETIC MOULDED PART

[001] The invention mainly relates to a method for the manufacture of prosthetic moulded parts for the dental sector, particularly so-called dental frames, with the aid of galvanic metal deposition, as well as to the resulting prosthetic moulded parts.

[002] It has long been known that an electrolytic metal deposition can also take place with pulse current, i.e. with current pulses interrupted by pauses or intervals. Such a metal deposition is also referred to as pulse-plating.

[003] As prior art reference is e.g. made to the "pulse-plating" volume in the electroplating and surface treatment pamphlet series, Leuze-Verlag, Saulgau, 1990.

[003] Electrolytic metal deposition with pulse current is mainly used for the application of thin metal coatings, e.g. in the electrical engineering and electronics fields. It is known that compared with deposition with direct current, pulse-plating generally is unable to bring about any increase in the deposition rate.

[004] It is now standard procedure in the dental sector to manufacture prosthetic moulded parts with the aid of galvanic metal deposition. The term used is galvanofarming. Mainly precious metals such as gold are used. The resulting three-dimensional moulded parts/mouldings can be used for known dental and prosthodontic purposes, particularly as so-called dental frames, to which plastic or ceramic is then applied as a veneer. Moulded parts are also galvanically produced, which are used for double crowns and bridges. It is also possible to directly use galvanically deposited mouldings.

[005] In the commercially usable methods and devices for galvanofarming in the dental sector comparatively long galvanizing or electroplating times are involved in order to obtain a moulding with an adequate coating thickness. This is inter alia due to the fact that high quality demands are made on the coating obtained. Thus, it is necessary to have a homogeneous coating structure and a very uniform coating thickness, so as to e.g. ensure the firing stability necessary for the application of a ceramic veneer. Minimum requirements must also be fulfilled with respect to further characteristics such as porosity, wear resistance, corrosion resistance, etc. Finally, the deposited coatings must more particularly in the dental sector satisfy special esthetic demands, e.g. with regards to the brightness or surface properties.

[006] Therefore the electroplating times for the manufacture of conventional prosthetic mouldings in dentistry when using conventional galvanizing or electroplating baths are several hours. For example the electroplating times in the case of a gold sulphite bath of the present applicant used in a versatile manner are 5 to 12 hours for the manufacture of conventional mouldings such as inlays, onlays, crowns, bridges, etc.

[007] It is also obvious that in the dental sector use is made of all the presently known, commercially employable methods and devices for galvanofforming with d.c. plating or deposition.

[008] The problem of the present invention is to further improve the manufacture of prosthetic dental moulded parts by galvanofforming. It is in particular to be achieved that the electroplating times can be reduced without impairing the quality of the deposited coatings. Finally, the invention is intended to provide dental prosthetics, which have at least equally good characteristics to the hitherto known dental prosthetics.

[009] This problem is solved by a method having the features of claim 1 and the dental prosthetic having the features of claims 16 or 17. Preferred embodiments are described in the dependent claims 2 to 15 and 18. The wording of all the claims is hereby made by reference into part of the content of the present description.

[010] According to the invention, the aforementioned method is characterized in that galvanic deposition takes place by pulse current deposition (pulse-plating). Pulse-plating may only represent a partial stage in the galvanic deposition overall, i.e. there is then at least one deposition stage under direct current. However, preferably galvanic metal deposition exclusively takes place by pulse-plating.

[011] The total electroplating or deposition time in the present invention is preferably less than 5 hours, particularly less than 3 hours. In further preferred embodiments electroplating times between 1 and 2 hours are obtained.

[012] An important parameter in the case of pulse-plating is the percentage pulse duration, i.e. the ratio of the time in which current flows to the total duration of deposition as a percentage. This quantity is also referred to as the duty cycle. In the invention percentage pulse durations between 10 and 99.9% are particularly appropriate. Within this range preference is given to values of at least 50%, preferably at least 70%. Pulse durations of at least 70% are chosen, particularly with electroplating times of less than 3 hours.

[013] In the invention the shape of the current pulses can be freely selected. Thus, it is possible to use all known pulse current shapes, such as e.g. sinusoidal pulse currents during deposition. It is also possible to work with the aid of unipolar or bipolar (reverse pulse) pulses. Double and multiple pulses, as well as pulse overlaps are also possible. Between individual current pulses the current intensity is normally, but not necessarily reduced to zero, i.e. the current is switched off. In the invention preference is given to square-wave or ramp-shaped pulses, particular preference being given to sharply defined, square-wave current pulses. In the case of short electroplating times the latter make it possible to manufacture mouldings with smooth, bright surfaces.

[014] In the invention the pulse current density is normally between 0.2 and 50 A/dm², especially between 1 and 20 A/dm² and in particularly preferred manner between 3 and 8 A/dm².

[015] The duration of the current pulses ("on period") and the duration of the current pauses or intervals ("off period" in the case of an interval current 0 or time with reduced current density) can be varied in the present invention. Normally the duration of the current pulses and/or the duration of the current intervals are in the microsecond or preferably millisecond range. In general terms the duration of the current pulses and the duration of the current intervals can be the same, so that during identical time periods alternately current flows or no or a reduced current flows. It is fundamentally also possible to vary the duration of the current pulses and/or the current intervals during the electroplating time, so that there is a succession of shorter or longer time periods in which current flows or no or reduced current flows, this taking place in a regular or irregular sequence.

[016] The duration of the current pulses (on period) is preferably at least 1 ms, particularly 20 to 100 ms. The duration of the current intervals is preferably at least 1 ms, particularly at least 4 ms, particular reference being made to off periods of 1 to 20 ms, preferably 4 to 12 ms.

[017] For reasons of completeness it is again stated that the invention relates to the galvanic deposition of metallic dental prosthetic parts. It is correspondingly obvious that the galvanofforming method (and the devices used for the same) are inter alia matched to the dimensions and sizes of such parts. Thus, such parts normally have surfaces to be coated between 10 and 400 mm². Particular reference is made within this range to values of 30 to 250 mm², particularly 50 to 200 mm². Conventional surfaces to be coated of inlays and crowns are between 100 and 200 mm². Account is taken of these dimensions when choosing the described method parameters such as percentage pulse duration, pulse shape, pulse current density and duration of the

current pulse/current interval.

[018] As has already been stated, in the method according to the invention it is possible to manufacture by galvanofforming all conventional dental prosthetics. Preferably manufacture takes place of prosthetic moulded parts with a thickness of at least 100 μm , particularly a thickness between 150 and 300 μm by pulse-plating. Such thicknesses are particularly desired in those cases where the moulding is to be subsequently veneered by firing on ceramic material. Particularly in the case of subsequent veneering with plastics coating thicknesses below 100 μm can also be adequate.

[019] The method according to the invention is preferably performed at a temperature above room temperature. Particularly during deposition the electroplating bath is heated to temperatures above 30°C, preferably between 50 and 80°C. Within the latter range particular reference is made to temperatures between 60 and 75°C. This measure helps to ensure a particularly rapid deposition in the present invention.

[020] The metal deposited and which is built up by galvanofforming to a three-dimensional moulding can fundamentally be any random metal which can be deposited from an electroplating bath. In the present case mainly the metals which can be deposited in dentistry are used. Particular reference is made in the series of non-ferrous metals to nickel, chromium, cobalt and molybdenum, which are used for dental materials such as NiCr-alloys, Ni-based alloys and CrCoMo-alloys. Preferably with the method according to the invention deposition takes place of a precious metal or a precious metal alloy. These can in particular be metals from the platinum group and silver. In particular, (pure) gold or a gold alloy are deposited.

[021] Galvanic deposition in the case of the method according to the invention normally takes place from a so-called galvanizing or electroplating bath, which contains in an adequate concentration the metal or metals to be deposited. The metal or metals to be deposited are present in the form of complexes. The baths also contain conventional additives such as deposition aids, brightening agents, etc. For ease of handling and environmental protection, in the case of the invention preference is given to the use of aqueous baths.

[022] The method according to the invention can be performed with particular advantage using an aqueous gold sulphite bath, which in particular has a basic pH-value. Said pH-value is preferably in the range 8 to 8.5. Such a gold sulphite bath is substantially non-toxic.

[023] When using the method according to the invention such a basic, aqueous gold sulphite bath leads to mouldings with a very uniform coating thickness

and limited internal stresses. It is also possible to provide very smooth, very bright surfaces. These advantages and in particular the uniform high coating thicknesses, are achieved over the entire moulding surface, e.g. also at points with undercuts or concave depressions.

[024] Fundamentally in the method according to the invention the already known galvanic baths, particularly the known, commercially available gold sulphite baths can be used. In order to fully utilize the advantages of the inventive method, it is preferred for the galvanic deposition to take place from a bath, which contains the metal or metals to be deposited in a higher concentration than in the hitherto known, conventional baths. For example, conventional gold sulphite baths used for depositing gold or gold alloys contain the gold in a concentration of up to 30 g/l (gram per litre). It is correspondingly preferred in the method according to the invention if the gold sulphite bath used has a gold concentration of more than 30 g/l. Gold concentrations between 40 and 60 g/l are more particularly preferred. Such baths with higher concentrations can be easily prepared by the expert on the basis of corresponding calculations and it is also possible to consider modified concentrations of further bath constituents such as brightening agents and the like.

[025] In the invention the application of the pulse current can take place in any random, known manner. Therefore the invention covers all forms of pulsed, potentiostatic depositions, in which it is not the current, but the voltage which is varied with corresponding pulse and interval times. The decisive criterion is that the electrolytic metal deposition takes place in "pulsed" manner.

[026] As stated, the invention also covers the prosthetic moulded part for the dental sector (dental prosthetic) obtainable by galvanofforming using the method according to the invention. This moulding is in particular manufactured according to the method of the invention. It can additionally be veneered with ceramic and/or plastic. With respect to the features and characteristics of the dental prosthetic according to the invention reference is made to the preceding description.

[027] The invention also covers the use of pulse-plating for the manufacture of prosthetic moulded parts for the dental sector. Here reference is made once again to the previous description.

[028] The advantages of the already described parts of the invention are inter alia that compared with the known galvanofforming methods, a much faster deposition and therefore manufacture of the moulding is possible. Thus, the dental technician performing deposition can consequently manufacture more dental prostheses than hitherto without the quality of the moulded parts

being impaired. On the contrary it is possible to produce mouldings with a better coating structure and more uniform coating thickness than was hitherto the case. This more particularly applies to mouldings having a complex structure, i.e. those which e.g. have undercuts or (small) concave depressions. A further advantage is that the use of the pulse current method in galvanofforming offers numerous further method performance possibilities. Thus, as a function of the particular case, it is possible to select and optimize the pulse current density, pulse and interval times, current pulse shape, percentage pulse duration and other parameters. This is not possible to the same extent with d.c. deposition or electroplating. For example it is possible to adjust the structure, e.g. by choosing a more or less fine-grained structure, or the surface properties can be modified. With respect to the latter frequently extremely smooth surfaces are desired. The invention also makes it possible to make available surfaces of varying roughness. Such rough surfaces can be advantageous if the moulding is to be veneered after deposition. In the case of such a veneering normally production takes place in a pretreatment stage of surface roughnesses, e.g. by particle bombardment. As a result the veneering material or associated bonds adhere better. Such a pretreatment can be obviated in the case of the aforementioned production of mouldings with a rough surface.

[029] Thus, new spheres of application are provided by the invention to galvanofforming in the dental sector, in which concentration had mainly been directed at optimizing the electroplating baths whilst maintaining d.c. electroplating and the comparatively long electroplating times.

[030] The invention finally covers an electrolytic cell, which is provided for the manufacture of prosthetic moulded parts for the dental sector (dental prosthetics) with the aid of galvanofforming by pulse current. In particular, said electrolytic cell is used for performing the method according to the invention and for manufacturing the moulding according to the invention. The content of claims 20 to 26 is, by reference, made into part of the content of the present description.

[031] According to the invention, besides other components necessary or appropriate for its function, the electrolytic cell contains an outer anode. The latter is constructed in such a way that it partly and preferably substantially completely surrounds one or more cathodes and namely along a circumferential line enclosing the cathode or cathodes. In other words the outer anode is constructed in such a way that the cathode or cathodes are located "within" the anode. The cathodes are parts which in electrolysis are located within the electrolytic cell in order to be coated with the metal or metals and in the present case e.g. prepared tooth stumps.

[032] Provided that the above condition is fulfilled, the outer anode can

fundamentally have any random design or configuration. Thus, the outer anodes can define random circumferential lines, e.g. stellate, rectangular, square or elliptical circumferential lines. Preference is given to an outer anode leading to a substantially circular circumferential line. Thus, in a preferred embodiment of the electrolytic cell according to the invention, a cylinder envelope-shaped, outer anode is used. The cylinder envelope-shaped, outer anode is preferably a so-called anode gauze, i.e. a cylinder envelope-shaped anode with an interrupted structure.

[033] The outer anode, which partly or substantially completely encloses in its interior the cathode or cathodes, can be constructed in one piece like the aforementioned cylinder envelope-shaped anode. However, the outer anode can also comprise several anode parts along the circumferential line. It is therefore possible e.g. in the case of an anode resulting in a circular circumferential line to construct the same from two anode parts with a semicircular cross-section or four anode parts with a quadrantal cross-section. With such constructions having a multipart, outer anode it is possible to leave gaps between the individual anode parts and they can receive bath liquid.

[034] The described electrolytic cell according to the invention preferably incorporates a further, inner anode, which (like the cathodes) is positioned within the circumferential line defined by the outer anode. This arrangement is preferably such that the cathodes are located in the area between the outer and inner anodes.

[035] In principle the inner anode can have any random shape or configuration. Correspondingly it can be constructed in the same way as the outer anode, preferably also with a cylinder envelope shape. This means that the inner anode can be an anode gauze, which with a correspondingly smaller diameter is located within the circumferential line defined by the outer anode. In particularly preferred embodiments the inner anode is a solid anode rod.

[036] With respect to the cathode or cathodes, the inner anode can in principle be arranged in random manner within the circumferential line defined by the outer anode. Thus, in the case where there is only one cathode in the electrolytic cell, said cathode and the inner anode face one another. The cathode and inner anode are preferably positioned symmetrically with respect to a centre, which is defined by the circumferential line of the outer anode. In electrolytic cell constructions where several cathodes are provided, the inner anode is preferably positioned centrally within the circumferential line defined by the outer anode. This has the advantage that the cathodes can be arranged symmetrically between the outer anode and the inner anode.

[037] In a further development shielding elements are provided in the electrolytic cell according to the invention and are in particular constructed as tubular or annular elements. These shielding elements are positioned between the outer anode and the cathode parts and/or between the inner anode and the cathode parts. These shielding elements prevent the cathodes to be coated, particularly in the case of high concentrations of the metal to be deposited in the electrolytic bath, being positioned too close to the anodes. When using tubular or annular shielding elements a material exchange can only take place via the upper and/or lower, open end of the corresponding components.

[038] Said shielding elements are preferably made from plastic, particularly Teflon.

[039] These and further features of the invention can be gathered from the following description of preferred embodiments in conjunction with the subclaims and drawings. The individual features can be implemented individually or in the form of subcombinations. In the drawings show:

Fig. 1 A diagrammatic representation of an insert part with an outer and an inner anode for an electrolytic cell according to the invention.

Fig. 2 A diagrammatic sectional view of an electrolytic cell according to the invention.

[040] The insert part 1 for the electrolytic cell according to the invention and which is only diagrammatically shown in fig. 1 has a flat upper part 2 in the manner of a lid. This upper part 2 is intended for placing or inserting the insert part 1 in an electrolytic cell. In a standard case the electrolytic cell can comprise a beaker and the insert part 1, together with further accessories.

[041] The insert part 1 has at least two elongated holding elements 3, to which is fixed an outer anode 4 in the form of a cylinder envelope-shaped platinized titanium gauze. The holding elements 3 simultaneously serve as a feed line. The outer anode 4 defines a circular circumferential line and an inner space formed within the outer anode 4.

[042] Directly within the outer anode 4 is provided a cylinder envelope-shaped, Teflon shielding element 5, which preferably is not in contact with the outer anode 4.

[043] In the inner space bounded by the outer anode 4 and the shielding element 5 is located a further cylinder envelope-shaped shielding element 6,

which is also made from Teflon. Said shielding element 6 is eccentrically positioned in the inner space. In the interior of the shielding element 6 is located an inner anode in the form of an anode rod and which is not shown in fig. 1, but which is also formed from platinized titanium.

[044] A feed line 7 for a cathode part not shown in fig. 1 is guided through the upper part 2 of the insert part 1 facing the shielding element 6 and therefore also the inner anode. Prior to electrolysis the prepared tooth stump to be coated is e.g. fixed to said feed line 7.

[045] Finally fig. 1 shows a further feed line 8 for the outer anode 4 and the inner anode located within the shielding element 6. Further conventional components of an electrolytic cell are not shown in fig. 1, but can e.g. be temperature sensors, stirrers, seals, protective rings, etc.

[046] Fig. 2 is a diagrammatic sectional view of an electrolytic cell according to the invention. The electrolytic cell 11 has a beaker 12, which is filled with a necessary or appropriate electroplating bath quantity. In fig. 2 it is possible to see within the beaker 12 a cylinder envelope-shaped, outer anode 13 defining a circular circumferential line. Said outer anode 13 can e.g. be a platinized titanium gauze. The inner space defined by the outer anode 13 can contain, adjacent to said outer anode 13, a cylinder envelope-shaped, Teflon shielding element 14.

[047] Fig. 2 shows another, cylinder envelope-shaped shielding element 15 eccentrically positioned in said inner space. Within said shielding element 15 is located an inner anode 16, which is in the form of a solid material rod. Symmetrically facing the shielding element 15 and inner cathode 16 is provided a tooth stump serving as the cathode part 17, which is to be coated with the aid of the electroplating bath e.g. with gold to form a dental prosthetic.

Examples

[048] In the three following examples manufacture takes place of a dental prosthetic, which is firing-stable and to be veneered with ceramic in accordance with the galvanofarming method according to the invention. The dental prosthetic has the form of a (galvano) crown.

[049] In all three cases a duplicate of the tooth stump is produced from the master model. This duplicating process takes place in a manner known to the expert, e.g. using plaster. Subsequently the tooth duplicate stump serving as a cathode during deposition is provided with a feed line (e.g. copper rod) and is e.g. made conductive with a conducting silver varnish.

[050] The apparatus used for deposition is constructed essentially as shown in the drawings and comprises a heatable magnetic stirrer supplied by Heidolph (type MR 3003), a temperature sensor supplied by Heidolph (type EKT 3000) and a current/voltage source suitable for pulse-plating (potentiostat/galvanostat model 263A of EG & G). The electrolytic cell is a 100 ml beaker with a cover and a matching magnetic stirring rod. The anode comprises two anode parts, namely a cylinder envelope-shaped, platinized titanium gauze and an anode rod centrally positioned in the inner space formed by the gauze and also made from platinized titanium. For shielding the cathode part or parts, between the gauze and cathode part or parts and the rod is concentrically inserted a Teflon ring (larger diameter) or Teflon tube (smaller diameter).

[051] An aqueous gold sulphite bath with a basic pH-value is used as the electroplating bath in all three examples. In examples 1 and 2 use is made of a gold bath with a gold concentration of 48 g/l in a 40 ml bath quantity and which is derived in known manner from a lower concentration gold bath, e.g. the bath used in example 3. In example 3 use is made of an AGC® gold bath of the present applicant with a gold concentration of 30 g/l (article no. 6781) in a bath quantity of 50 ml. In all three cases addition takes place of an AGC® brightener additive of the applicant, namely in examples 1 and 2 additive article no. 6624 (4x concentrated) in a quantity of 3 ml per cathode part and in example 3 additive article no. 6674 in a quantity of 4 ml per cathode part.

[052] The electroplating conditions in the three examples were as follows:

Example 1

Electroplating time:	2 hours
Electroplating temperature:	approx. 70°C
Square-wave pulse shape:	
Pulse current density:	3.6 A/dm ²
Percentage pulse duration:	86%
Current pulse duration:	24 ms
Current interval duration:	4 ms

Example 2

Electroplating time: 1 hour
Electroplating temperature: approx. 70°C
Square-wave pulse shape:
Pulse current density: 7.3 A/dm²
Percentage pulse duration: 88%
Current pulse duration: 24 ms
Current interval duration: 4 ms

Example 3

Electroplating time: 4 hours
Electroplating temperature: approx. 70°C
Square-wave pulse shape:
Pulse current density: 1.6 A/dm²
Percentage pulse duration: 88%
Current pulse duration: 72 ms
Current interval duration: 12 ms

[053] In all three examples gold-coloured, very bright galvano-crowns with an extremely smooth surface are obtained. The coating thickness of approximately 200 µm is very uniform over the entire galvano-crown and has a perfect coating structure. There is also a very uniform, fine-grained structure, which is free from voids and holes. All three galvano-crowns are firing-stable during ceramic veneering.

CLAIMS

1. Method for the manufacture of prosthetic moulded parts for the dental sector, particularly dental frames, with the aid of galvanic metal deposition, in which galvanic deposition at least partly and preferably completely takes place by pulse-plating, characterized in that gold or a gold alloy is deposited and that the percentage pulse duration, based on the total deposition time, is at least 50%.
2. Method according to claim 1, characterized in that galvanic deposition is ended in a time of less than 5 hours, preferably less than 3 hours.
3. Method according to claim 2, characterized in that galvanic deposition is ended within 1 to 2 hours.
4. Method according to one of the preceding claims, characterized in that the percentage pulse duration is at least 70%.
5. Method according to one of the preceding claims, characterized in that square-wave or ramp-shaped current pulses, particularly sharply defined, square-wave current pulses are used.
6. Method according to one of the preceding claims, characterized in that the pulse current density is between 0.2 and 50 A/dm², preferably between 3 and 8 A/dm².
7. Method according to one of the preceding claims, characterized in that the duration of the current pulses and/or current intervals is in the millisecond range.
8. Method according to claim 7, characterized in that the duration of the current pulses is at least 1 ms, preferably between 20 and 100 ms.
9. Method according to claim 7 or 8, characterized in that the duration of the current intervals is at least 1 ms, preferably between 4 and 12 ms.
10. Method according to one of the preceding claims, characterized in that the prosthetic moulded part is deposited with a thickness of at least 100 µm, preferably between 150 and 300 µm.
11. Method according to one of the preceding claims, characterized in that galvanic deposition takes place from an aqueous bath.

12. Method according to one of the preceding claims, characterized in that galvanic deposition takes place from a gold sulphate bath.
13. Method according to one of the preceding claims, characterized in that galvanic deposition takes place from a bath, which contains the metal to be deposited in a higher concentration than conventional baths.
14. Method according to claim 13, characterized in that a gold sulphite bath has a gold concentration of more than 30 g/l and preferably between 40 and 60 g/l.
15. Prosthetic moulded part for the dental sector, particularly dental frame, obtainable according to the method of at least one of the claims 1 to 14.
16. Prosthetic moulded part for the dental sector, particularly dental frame, manufactured according to the method according to at least one of the claims 1 to 14.
17. Prosthetic moulded part according to claim 15 or 16, characterized in that it is veneered with ceramic and/or plastic.
18. Use of pulse-plating for the manufacture of prosthetic moulded parts for the dental sector, characterized by at least one of the features of claims 1 to 14.
19. Electrolytic cell for the manufacturer of prosthetic moulded parts for the dental sector with the aid of galvanic metal deposition by pulse current or pulse-plating, particularly for performing the method according to one of the claims 1 to 14, comprising an outer anode (13) constructed in such a way that it at least partly and preferably substantially completely surrounds a cathode (17) to be coated with metal and which can be placed in the electrolytic cell, along a circumferential line enclosing the cathode.
20. Electrolytic cell according to claim 19, characterized in that the outer anode has several anode parts along the circumferential line.
21. Electrolytic cell according to claim 19 or 20, characterized in that the outer anode is cylinder envelope-shaped.
22. Electrolytic cell according to one of the claims 19 to 21, comprising a further, inner anode (16), which is located within the circumferential line defined by the outer anode (13), preferably in such a way that the cathode (17) is located between the outer and the inner anodes.

23. Electrolytic cell according to one of the claims 19 to 22, characterized in that the inner anode (16) is an anode rod, which is preferably centrally positioned within the circumferential line defined by the outer anode.

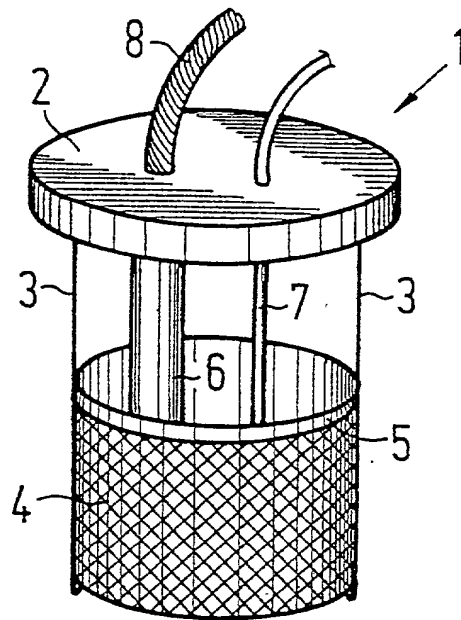
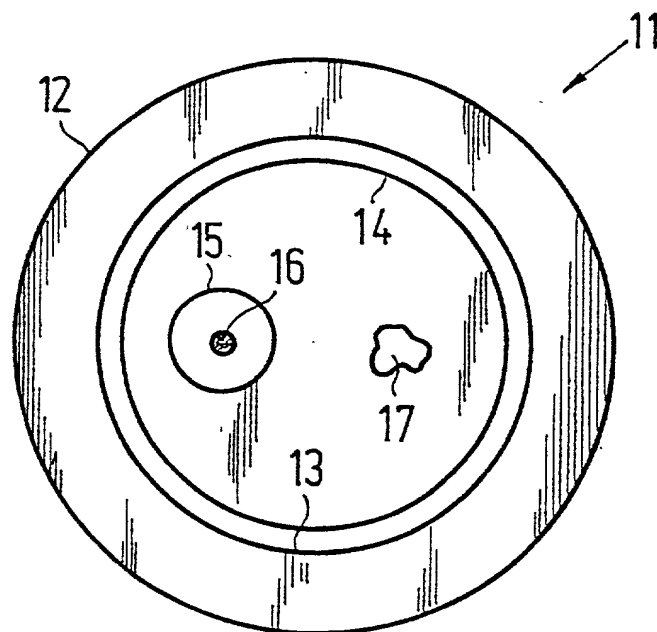
24. Electrolytic cell according to one of the claims 19 to 23, characterized in that between the outer and/or inner anode and the at least one cathode are provided shielding elements (14, 15), which are preferably constructed as tubular or annular elements.

25. Electrolytic cell according to claim 24, characterized in that the shielding elements are made from plastic, particularly Teflon.

ABSTRACTMETHOD FOR THE MANUFACTURE OF PROSTHETIC MOULDED PARTS
FOR THE DENTAL SECTOR AND PROSTHETIC MOULDED PART

In a method for the manufacture of prosthetic moulded parts for the dental sector with the aid of galvanic metal deposition, deposition at least partly takes place by pulse current. Deposition is preferably ended in a period of less than 5 hours, particularly within 1 to 2 hours. Deposition preferably takes place in the method of a precious metal or precious metal alloy, particularly gold or a gold alloy. Aqueous gold sulphite baths are more particularly used.

1/1

FIG.1FIG.2

DECLARATION FOR PATENT APPLICATION

Attorney Docket 24552

MAY 15 2001

As a below-named inventor(s), I/we hereby declare that

My residence(s), post office address(es) and citizenship(s) is/are as stated below next to my/our name(s).

I/We believe I/we am/are the original inventor, first and sole (if only one name is listed below) or the original, first and joint inventors (if plural names are listed below) of the subject matter which is claimed, and for which a patent is sought on the invention entitled: **Method for producing prosthetic moulded parts for dental use and prosthetic moulded part**
the specification of which: (check one)

☐ is attached hereto.

☒ was filed on 30 Sept. 1999, as Serial No. PCT/EP99/07257,
30 March, 2001 09/806,442
and was amended on 19 (if applicable)

We hereby state that we have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

We acknowledge the duty to disclose information which is material to the patentability of this application as defined by 37 CFR § 1.56.

We hereby claim foreign priority benefits under 35 U.S.C. § 119 of any foreign application(s) for patent or inventor's certificate listed below, and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

Prior Foreign Applications:

<u>198 45 506.2</u>	<u>Germany</u>	<u>02. / 10 / 1998</u>	Priority Claimed
(Application No.)	(Country)	(Day/Month/Year Filed)	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No
<u> </u>	<u> </u>	<u> </u>	<input type="checkbox"/> Yes <input type="checkbox"/> No
(Application No.)	(Country)	(Day/Month/Year Filed)	<input type="checkbox"/> Yes <input type="checkbox"/> No
<u> </u>	<u> </u>	<u> </u>	<input type="checkbox"/> Yes <input type="checkbox"/> No
(Application No.)	(Country)	(Day/Month/Year Filed)	<input type="checkbox"/> Yes <input type="checkbox"/> No

124 We hereby appoint Gary M. Nath, Reg. No. 26,965; Harold L. Novick, Reg. No. 26,011; Suet M. Chong, Reg. No. 38,104; Todd L. Juneau, Reg. No. 40,669; Patricia M. Drost, Reg. No. 29,790; Lee C. Helman, Reg. No. 41,827; Jerald L. Meyer, Reg. No. 41,194; Joshua B. Goldberg, Reg. No. 44,126; David Milligan, Reg. No. 42,893 and Robert G. Lev, Reg. No. 30,280; David R. Murphy, Reg. No. 22,751; Paul A. Sacher, Reg. No. 43,418; Gregory B. Kang, Reg. No. P-45,273; Scott F. Yarnell, P-45,245; as my attorneys to prosecute this application and transact all business in the U.S. Patent and Trademark Office connected therewith.

Dir. Telephone Calls to:

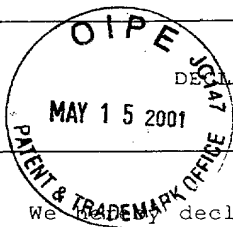
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We hereby claim the benefit under 35 U.S.C. § 120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by 35 U.S.C. § 112, first paragraph, I/we acknowledge the duty to disclose material information as defined in 37 CFR § 1.56 which occurred between the filing date of the prior application and the national or PCT international filing date of this application:

(U.S. Application Serial No.)	(U.S. Filing Date)	(Status--patented, pending, abandoned)
<u> </u>	<u> </u>	<u> </u>
(U.S. Application Serial No.)	(U.S. Filing Date)	(Status--patented, pending, abandoned)
<u> </u>	<u> </u>	<u> </u>



DECLARATION FOR PATENT APPLICATION

Attorney Docket: 24552

We declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements are made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under 18 U.S.C. § 1001 and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Full name of sole or first inventor: RUEBEL, SusanneInventor's Signature Susanne Ruebel Date 22/03/01Residence: D - 76307 Auerbach, GermanyCountry of Citizenship: German DEXPost Office Address: Remchinger Strasse 65, D - 76307 Auerbach, Germany

Full name of second inventor: _____

Inventor's Signature _____ Date _____

Residence: _____

Country of Citizenship: _____

Post Office Address: _____

Full name of third inventor: _____

Inventor's Signature _____ Date _____

Residence: _____

Country of Citizenship: _____

Post Office Address: _____

Full name of fourth inventor: _____

Inventor's Signature _____ Date _____

Residence: _____

Country of Citizenship: _____

Post Office Address: _____